

Date: Monday, 07/07/2008 4:23:15 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 40345		
Estimate Number	: 13273		
P.O. Number	:	Part Number	: D32023
This Issue	: 07/07/2008 S.O. No. :	Drawing Number	: D3202 REV 02 OK
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: 02 08/07/15
Previous Run	: 39331	Material	:
Written By	:	Due Date	: 18/07/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUL 08-7-07</u>		
Comment	: Est Rev:A new issue 08-04-21 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S032	5052-H32 .032 Sheet
-----	--------------	---------------------



Comment: Qty.: 1.6286 sf(s)/Unit Total : 19.5426 sf(s)

5052-H32 .032 Sheet

Batch: 108462 HB 8-7-15

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3202

Dwg Rev: C

Prog Rev: C

HB 8-7-15

(13)

2-Deburr if necessary

HB 8-7-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-7-15

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/07/15 (13)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

08-07-16

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:23:15 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 40345

Part Number: D32023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M106447



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

9:30 AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:00 AM

HL

08-07-16

(X13)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

08/07/16

(13X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

H5 238A

8/7/16

N13

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/18

Job Completion



U 08.07.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

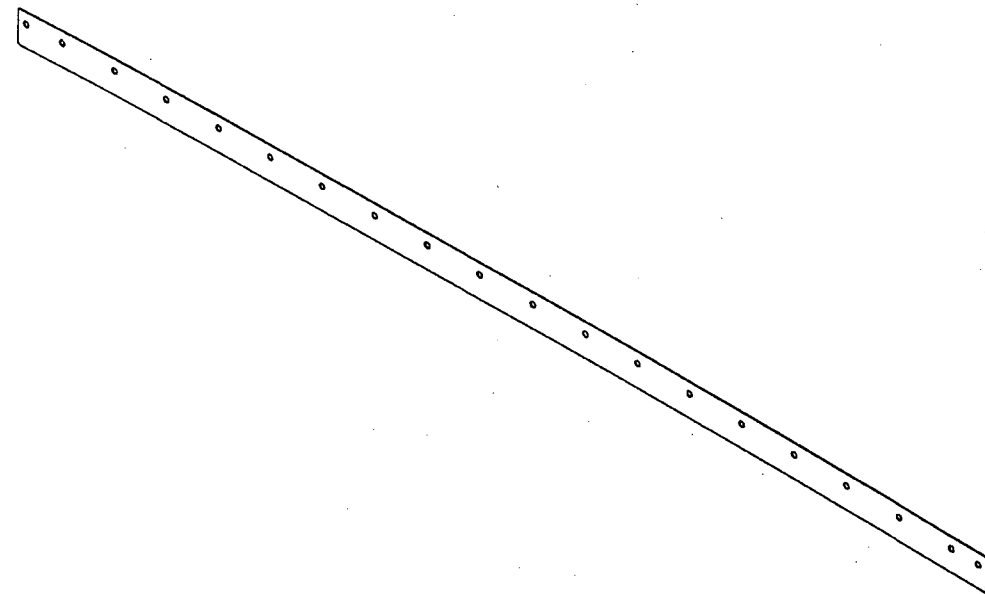
1

D

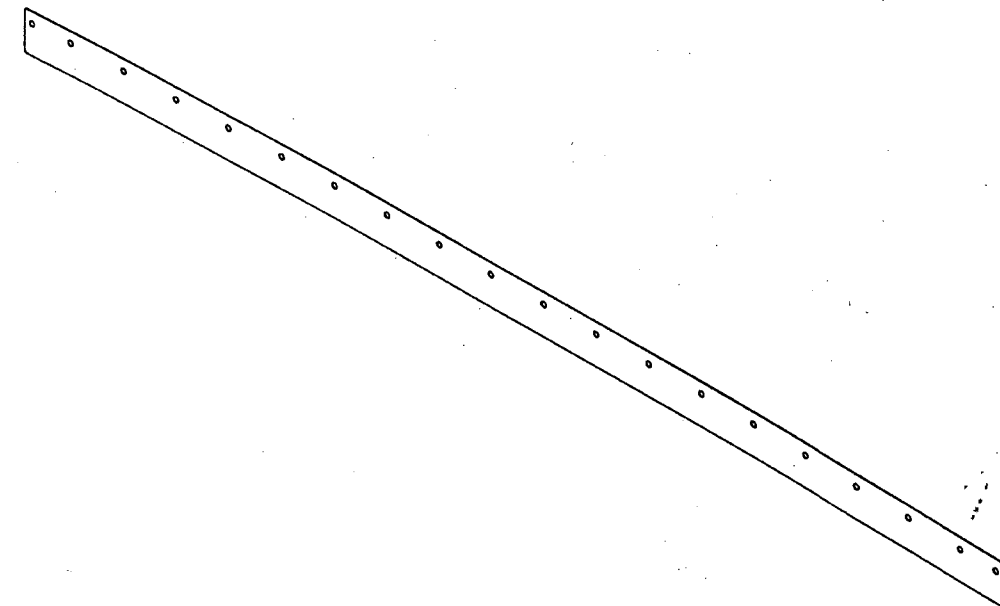
C

B

A



D3202-1 COVER



**D3202-3 COVER
(COMPOSITE DOOR)**

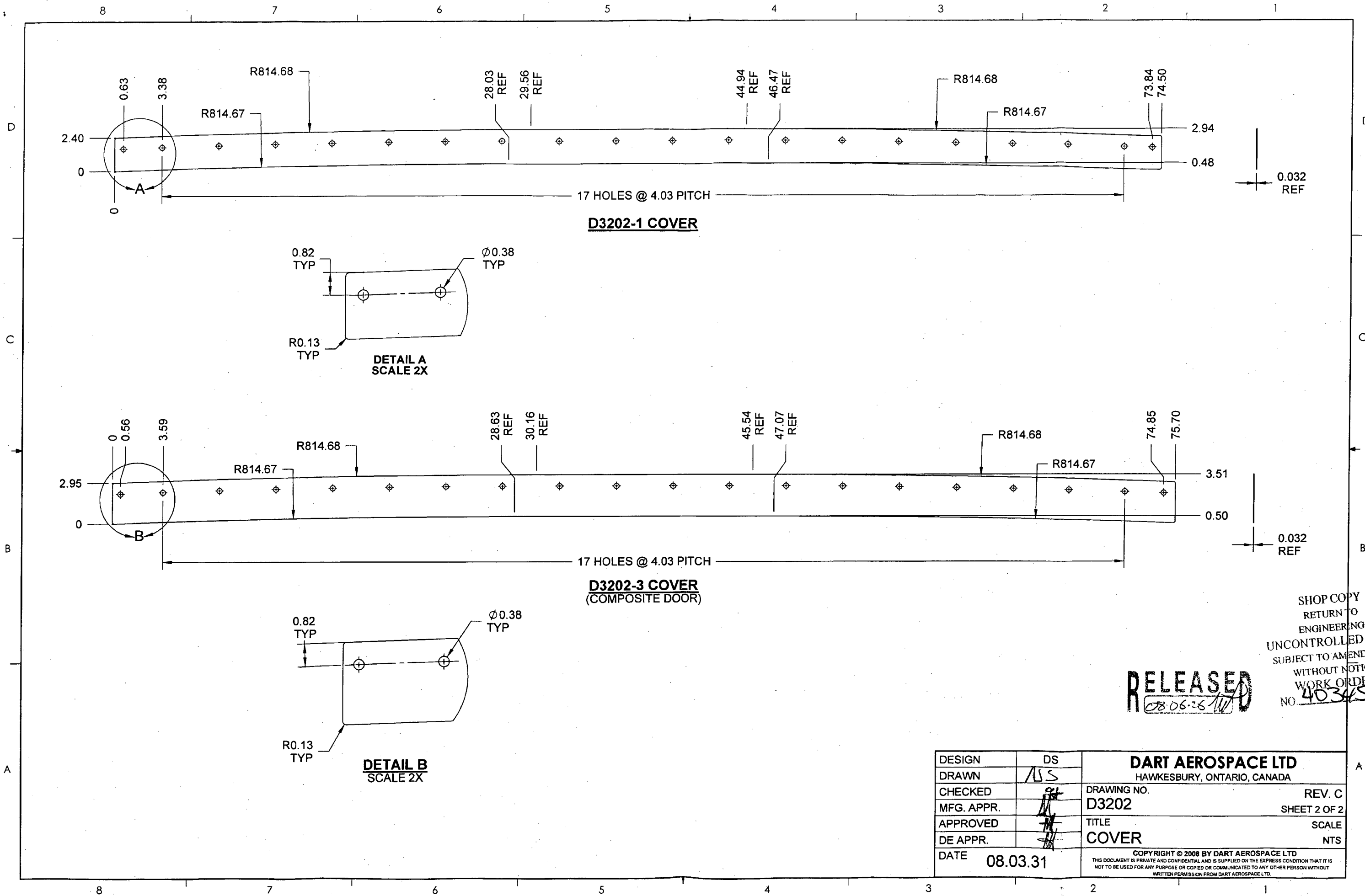
NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40345

RELEASED
08-03-26

C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3202	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40345

RELEASED
08-06-26

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MS		
CHECKED	MS	DRAWING NO.	REV. C
MFG. APPR.	MS	D3202	SHEET 2 OF 2
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	COVER	NTS
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD	Work Order:	40345
Description: COVER	Part Number:	D3202-3
Inspection Dwg: D3202-3 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by:	RB	Audited by:	[Signature]	Prototype Approval:	[Signature]
Date:	8-7-15	Date:	08/07/15	Date:	8/7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	